

# Work Order ID 58270

May 3, 2010 9:52:19 AM



Page 1

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly LH

Stop



Start Date: 03/05/2010 Start Qty: 1.00

Required Date: 13/05/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2991	D								
IIN-D350-589	E								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-041

CHG005

8-01/12/14

Jchr BG 10-12-14

Door is at Rev D

103

0.00



Small Fab

Memo

0.00

Small Fab

1- Trim edge of door to fit moc up helicopter

JS 10-11-15 (x1)

W/O: 58270		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-11-15	103	install D2992-1 Doublers as per Dwg D2991 D2992-1 x2 B 47743 Paminate w/hysol 956 m 113477 exp 10-12-17	ET	10-12-02			S 10/12/02
10-11-15	103	pot holes as shown in section E-E w hysol 956 + milled glass fiber hysol 956 m 113477 exp 10-12-17 milled fiber m 100859	ET	10-12-02			S 10/12/02

Part No: D350-589-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

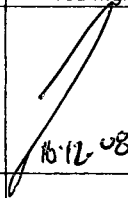
Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				1			10/11/15
110 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00				85		10-12-06	
140 	Small Fab	0.00							
Small Fab Small Fab	Memo	0.00				85		10-12-06	P50
	Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-08-06	103	Prime inside of door using LE 3404S primer filler + activator LE 117TS reducer B 115462 Paint outside surface of door using Duron 3.5 HG paint + iron UGM-6005 activator B 116066	RT	10-12-07		 10/12/08	S 10/12/08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/01/2/08

(H)

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/13 SP

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/01/2/14

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
	Memo	0.00							
	Identify and pack for shipping as per PPP D350-589-041								
	Location: <u>U2</u>								
	PPP rev: <u>SG</u>								
190 	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

10/12/14 SP

10/12/15 JF

ME  
10-12-14

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 58270

Parent Item: D350-589-041

Parent Item Name: Side Door Assembly LH

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC  
 IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC  
 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD IPP Rev:D add seq 103/105

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2991-1 Manufactured No  
 Side Door

110 Each 1.0000 1  
 358272

10-12-08

Location	Loc Qty	Loc Code
CA	1	
56809	1	
	Each	1.0000

DSI 9446-011 Manufactured No  
 Switch Relocation

Almethe en stock

B62092 10/12/13

Location	Loc Qty	Loc Code
FG020	1	
45595	1	
	Each	3.0000

DSI 9447-011 Manufactured No  
 Latch Adjustment

10/12/13

Location	Loc Qty	Loc Code
FG020	3	
53111	3	
	Each	109.0000

D2621 Manufactured No  
 Latch Plate, 350 Spacepod

10-12-08

Location	Loc Qty	Loc Code
ST021	109	
46842	40	
56526	69	

W/O:		WORK ORDER CHANGES					
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 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD IPP Rev:D add seq 103/105

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No 110 Each 65.0000 3



Door Latch

B61655



RT 10-12-08

Location Loc Qty Loc Code  
 ST204 65

55314 65

MS27039-1-15 Purchased No 110 Each 98.0000 3



Screw

M114718



RT 10-12-08

Location Loc Qty Loc Code  
 ST292 98

112794 3

114056 95

\* D2464-1700 Manufactured No 110 Each 0.0000 1



Neoprene Seal

B48173



RT 10-12-08

D3085-041 Manufactured No 110 Each 8.0000 1



prop ass'y



RT 10-12-08

Location Loc Qty Loc Code  
 ST271 8

47687 4

57545 4

RT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 verified; DD IPP Rev:D add seq 103/105

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2585 Manufactured No 110 Each 87.0000 3



Mounting Channel

362676



RT 10-12-08

Location Loc Qty Loc Code

ST018 49

55313 49

ST019 38

56524 38

MS21042L3 Purchased No 110 Each 1,770.000



Nut

M114784



RT 10-12-08

Location Loc Qty Loc Code

ST300 1770

113537 20

113644 750

114523 1000

AN960JD10 Purchased No 110 Each 0.0000 3



Washer

M115622



RT 10-12-08

MS20470AD4-5 Purchased No 160 Each 217.0000 6



Rivet, Universal Head



M114761 10/12/13

Location Loc Qty Loc Code

ST319 217

111916 217

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 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD IPP Rev:D add seq 103/105

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-4A  
  
 Bolt

Purchased No 160 Each 1,448.000 6



10/12/13

Location	Loc Qty	Loc Code
ST350	1448	
104214	287	3
104291	300	
104322	200	
104374	200	
104625	300	
104817	161	3

D2237  
  
 Striker Plate

Manufactured No 160 Each 75.0000 3



B62212 10/12/13

Location	Loc Qty	Loc Code
ST009	40	
57255	40	
ST010	35	
55312	35	

D2589  
  
 Keys, Key Chain, 350 Hinge

Manufactured No 160 Each 265.0000 1



10/12/13

Location	Loc Qty	Loc Code
ST019	265	
58194	265	3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 verified: DD IPP Rev:D add seq 103/105

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

1,770.000

6

Nut

Location

Loc Qty

Loc Code

ST300

1770

113537

20

113644

750

114523

1000



M114784 10/12/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

# DART SERVICE INSTRUCTION

REFERENCE ONLY

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER  
REF. TCCA STC: SH92-41  
REF. FAA STC: SH1012NE  
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x  $\varnothing 0.129$  (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

## PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
<input checked="" type="checkbox"/> X	DSI 9446-011	Switch Relocation Kit
1	D3894-1f	Switch Plate

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: D. Shepherd  
D. SHEPHERD (DE # 02)

DATE: 09.02.03  
CERT. NO.: SH92-41  
ISSUE NO.: 7

A	NEW ISSUE	09.02.03	
REV.	DESCRIPTION	BY DATE	
DESIGN	DSI	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DSI		
CHECKED	DSI		
MFG. APPR.	N/A		
APPROVED	DSI		
DE APPR.	DSI	DRAWING NO. DSI 9446	REV. A
DATE	09.02.03	TITLE SWITCH RELOCATION	SCALE NTS
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REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41

REF. FAA STC: SH1012NE

REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x  $\varnothing 0.129$  (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes  $\varnothing 0.179 \times 100^\circ$  from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

## PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.02.04  
CERT. NO.: SH92-41  
ISSUE NO.: 7

A	NEW ISSUE	09.02.04
REV.	DESCRIPTION	BY DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9447 SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT NTS
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## Change Record

Part Number D350-589-041

Description Side Door Assembly

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